

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 82.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018474**Date Inspected:** 22-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1330**Contractor:** Westmont Industries**Location:** Santa Fe Springs, CA.**CWI Name:** Ruben Dominguez**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Travelers**Summary of Items Observed:**

The Quality Assurance Inspector Sean Vance arrived on site at Westmont Industries (WMI) in Santa Fe Springs, CA, to randomly observe the in process welding, QC inspection and non-destructive testing of the Travelers.

Upon the arrival of the QA Inspector, the following observations were made:

**Traveler Test Rack**

On this date, the QA Inspector observed WMI production personnel performing fitting, welding and cutting activities on various assemblies for the Traveler Test Rack.

**SAS-EB Traveler****Fixed Stairs Section**

On this date, the QA Inspector observed Westmont Industries (WMI) production welder, Mr. Jose Rodriguez (WID # 3031), continuing to perform Flux Core Arc Welding (FCAW) activities on the previously fit Frame assemblies, identified as 10-A237, 11-B237, 3-A217, 4-A218, 5-A223 and 6-A224. The QA Inspector observed throughout the shift, that the FCAW was being performed in various positions, on the connector plate and Tube Steel (TS) material fillet and flare groove welds.

**Lower Truss Section**

On this date, the QA Inspector observed Westmont Industries (WMI) production welder, Mr. Eutimo Lopez (WID # 3035), continuing to perform Flux Core Arc Welding (FCAW) activities on the previously fit Frame assemblies, identified as 12-A240, 13-B240, 7-A225, 8-A226 and 9-A230. The QA Inspector observed throughout the shift, that the FCAW was being performed in various positions, on the connector plate and Tube Steel (TS) material

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fillet and flare groove welds.

The QA Inspector observed WMI production personnel Mr. Raymundo Anaya (WID # 3196) and Mr. Cesar Canales performing fitting and Flux Core Arc welding (FCAW) activities on the Elevating Platform, for the Lower Truss Section. The QA Inspector observed that the fitting and tacking activities were being performed on the Stair Risers, piece marks identified as C270F, to Stair Supports, piece marks identified as A270F and B270F. The QA Inspector observed that the fitting and tacking activities were also being performed on what appeared to be various plate material fillet and flare groove welds. In addition, the QA Inspector observed Mr. Anaya and Mr. Canales performing fitting and tacking activities on the Platform Balcony Assembly, for the Lower Truss Section. The QA Inspector observed the activities being performed on channel and Tube Steel (TS) material. The QA Inspector then referenced the nearby shop drawings and the Platform Balcony appears to connect to the Elevating Platform Assembly.

See attached pictures below.

### E2/E3-EB Traveler

On this date, the QA Inspector observed WMI production welder Mr. Juan Jimenez (WID # 3059), continuing to perform Flux Core Arc Welding (FCAW) welding activities on the intermediate and diagonal bracing Tube Steel (TS) material. The QA Inspector observed that the FCAW being performed by Mr. Jimenez appeared to be for the Frame Assembly identified as 9-A332 and 10-B332, per the shop drawings. The QA Inspector observed that the weld joints appeared to be designated as 6mm fillet and flush flare groove welds and that Mr. Jimenez was performing the FCAW in the flat (1G) and vertical (3F) positions, throughout the shift.

The QA Inspector randomly observed that Smith-Emery QC Inspector Ruben Dominguez was present, during the above mentioned welding and fitting activities and QC Inspector Dominguez explained that approved Welding Procedure Specifications (WPS's) were being utilized. During random observation, the QA Inspector observed that the applicable WPS's and copies of the shop drawings, were located near each work station, where the above mentioned welding and fitting activities were being performed. The QA Inspector randomly verified that the consumable material, utilized during the welding appeared to be in compliance with the applicable WPS and that the above mentioned welders were currently qualified for the applicable process and position of welding. The QA Inspector randomly observed QC Inspector Dominguez verifying the in-process welding parameters, including voltage, amperage, pre-heat and travel speed and the parameters appeared to be in compliance to the applicable WPS.

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## Summary of Conversations:

On this date, the QA Inspector spoke with SE QC Inspector Dominguez regarding the previously cut out 5 mm and 6mm fillet welds, on the SAS-EB Lower Truss Elevating Platform. During conversation, Mr. Dominguez explained that he had previously explained to production supervision that ABF should be notified, prior to cutting out the welds. Mr. Dominguez further explained that he wasn't sure that ABF had been notified, prior to cutting. The QA Inspector then spoke with WMI QA Representative Curt Bell and Mr. Bell explained that ABF had been notified, prior to cutting. The QA Inspector explained to Mr. Bell that the cutting of the welds appeared to performed, prior to a response from ABF and if this was correct, that WMI should generate a corrective action or Non Conformance, for the activities which were performed. Mr. Bell explained that he will look into this matter further.

The QA Inspector also spoke with WMI Representative Brad Petrie, regarding this incident. The QA Inspector explained to Mr. Petrie that if the cutting out of the welds was performed prior to ABF notification and approval of the engineer, that a Corrective Action of Non Conformance should be generated for the activities. Mr. Petrie explained that he will look into this matter further.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Vance,Sean	Quality Assurance Inspector
<b>Reviewed By:</b>	Edmondson,Fred	QA Reviewer

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